:Date: User: Friday, 24/10/2008 3:31:29 PM

Julie Dawson

Process Sheet

Customer Job Number

Prsht Rev.

First Issue

: CU-DAR001 Dart Helicopters Services

: 42945

Estimate Number

: 11535

P.O. Number

This Issue

: 24/10/2008

: NC

: // : 40492

Type

: SMALL /MED FAB

Part Number

Drawing Name

Drawing Number

: D30403 . D3040 REV B

: MOUNTING LUG

Project Number

: N/A : B **Drawing Revision**

Material **Due Date**

: 07/11/2008

Qtv:

30 Um:

Each

Written By Checked & Approved By

Comment

Previous Run

S.O. No. :

Revised Step 2 and Added Inspection Level 21 S

М

Est Rev:A Now on Waterjet 07-03-07 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0187X04000

6061-T6 Bar .178" x 4.0"

6061-T6 Bar .178 x 4.00

ð

106653 205=9-3

Comment: Qty.:

0.3718 f(s)/Unit Total:

11.1542 f(s)

13 8-11-11

Material: 6061-T6 alum plate 0.188" thick

Batch:

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3041

Dwg Rev:__ Prog Rev:_

871-11

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2

AB 871-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

08-11-11



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING

Identify and Stock Location:

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: \	es N	o DQ	A:	_ Date: _	
	Re	esolution:	Disposition	n:	QA: N/	C Clos	sed:		Date: _	
NCR:		•	WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE		Description of NC			tion B		Verific	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		Chief Eng	QC Inspecto
							77			
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Date: User: Friday, 24/10/2008 3:31:29 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 42945

Part Number: D30403

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										·
Part No	:	PAR #:	Fault Cat	egory:	NCR	: Yes N	lo DQA	۸:	Date:	
	R	esolution:	Dispositi	on:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONFOR	MANCE	(NCR))			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Description	Section B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
		Jection A	Chief Eng	Chief Eng		Date	Secilo	лго ———	Office Eng	QO INSPECTO
	:									
				-						

DART AEROSPACE LTD	Work Order: 142945
Description: Mounting Lug	Part Number: D3040-3
D0040	Poro 1 of 1
Inspection Dwg: D3040 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Х	First Art	icle	Prot	ototype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments		
Ø0.257	+0.006-0.001	026,	*						
3.413	+/-0.010		*						
0.188	+/-0.010	781,	X						

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					7				
Measured by:	R	Audited by:	mI		Prototype App	roval:	N/A		
Date:	8-11-11	Date:	 	K		Date:	N/A		

Rev	Date	Change	Revised by	Approv	<i>ı∉</i> d
A	07.04.20	New Issue	KJ/JLM O	Sill	
	J			77	

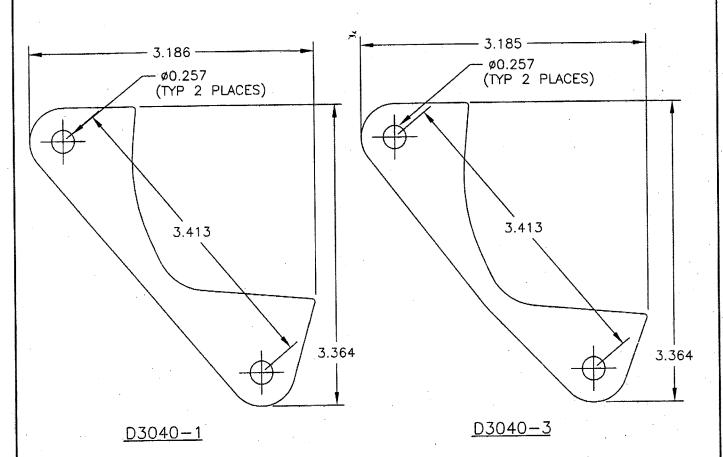
Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		,					·				
											
	-										
							··				
			•		_ NCR: Yes No DQA: Date:						
	R	esolution:	Disposition	n:	_ QA	: N/C CI	osed:		Date: _		
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.4.7.F	STEP	STEP Description of NC Section A	Corrective Action , Section B				Verific	ation	ation Approval Ap		
DATE			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	Approval QC Inspector	
			į								
					•						



DESIG	P	DRAWN BY	DART AEROSPACE USA, INC	
CHECK	CED A	APPROVED.	DRAWING NO. RE	V. B
	4	#	D3040 SHEET 1	OF 1
DATE			TITLE	CALE
01.0	9.04		MOUNTING LUG	1:1
Α		01.06.27	NEW ISSUE	
В		01.09.04	CHANGED PROFILE 5 DEGREES	





NOTES

SHOP COPY RETURN TO ENGINEERING

1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"

UNCONTROLLED COP

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THIGKBIECT TO AMENDMENT (REF M6061T6S.188)

3) FINISH: NONE

4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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Dart Aeı	rospace	Ltd						
W/O:			WC	ORK ORDER CHANGE	S			
DATE STEP		PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Clo	sed:	Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR)		
	T	Description of NC		Corrective Action Section	n B	Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
· .								<u></u>